

S148384

mif



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D3560-042
Job Sheet 188643



Part No: D3560-042

Job Qty: 4 pcs

Part Name: Arm Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 07.05.24 EC IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C
ECN1048 07-12-18 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	Large Fab - Welded Assy-1	4 pcs	1/25/19		0.00	3.08	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		SLG
150	QC 5	4 pcs	1/25/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		CPC
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
160	QC 9	4 pcs	1/25/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		CPC
							QC 9 - 43		

P.T.O.

170 Handfinish - 1-1 Chemical-B4B	4 pcs	1/25/19	0.00 0.57	QC 9 - 50	
				QC 9 - 9	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/01/29
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
180 QC 7	4 pcs	1/25/19	0.00 0.00	2Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	Cpl
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 38	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
190 Small Fab - 2 - B4B	4 pcs	1/25/19	0.00 0.13	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	DAS
				Small Fab - 3 - B4B	30
				Small Fab - 4 - B4B	9.35
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
200 QC 5		1/25/19	0.00 0.00	QC 5 - 10	

4
pcs

QC 5 - 12
QC 5 - 17
QC 5 - 18
QC 5 - 19
QC 5 - 22
QC 5 - 24
QC 5 - 3
QC 5 - 38
QC 5 - 42
QC 5 - 43
QC 5 - 49
QC 5 - 51
QC 5 - 58
QC 5 - 68
QC 5 - 9
QC 5 - 50
QC 5 - 30

[Handwritten signature]

210 Packaging 3-1 - Stock - B4B 4 1/25/19 0.00 0.00

4
pcs

Packaging 3 - 1 - B4B
Packaging 3 - 2 - B4B
Packaging 3 - 3 - B4B
Packaging 3 - 4 - B4B
Packaging 3 - 5 - B4B
Packaging 3 - 6 - B4B
Packaging 3 - 7 - B4B
Packaging 3 - 8 - B4B
Packaging 3 - 9 - B4B
Packaging 3 - 10 - B4B
Packaging 3 - 11 - B4B
Packaging 3 - 12 - B4B
Packaging 3 - 13 - B4B
Packaging 3 - 14 - B4B
Packaging 3 - 15 - B4B
Packaging 3 - 16 - B4B
Packaging 3 - 17 - B4B
Packaging 3 - 18 - B4B
Packaging 3 - 19 - B4B
Packaging 3 - 20 - B4B
Packaging 3 - 21 - B4B
Packaging 3 - 22 - B4B
Packaging 3 - 23 - B4B
Packaging 3 - 24 - B4B
Packaging 3 - 25 - B4B
Packaging 3 - 26 - B4B
Packaging 3 - 27 - B4B
Packaging 3 - 28 - B4B
Packaging 3 - 29 - B4B
Packaging 3 - 30 - B4B
Packaging 3 - 31 - B4B
Packaging 3 - 32 - B4B
Packaging 3 - 33 - B4B
Packaging 3 - 34 - B4B
Packaging 3 - 35 - B4B

220 QC 21 - SA 4 1/25/19 0.00 0.00

4
pcs

QC 21 - SA - 21
QC 21 - SA - 70

QAL

21 JAN 20 2019

Part Op 140 - (Weld per dwg A/R Aluminum rod Batch: _____), 1-Weld assembly as per dwg D3560 10- from half way point weld
Descriptions: the rest of the first side (ease off pedal near end) 11- same for remaining side (ease off pedal near end)

- 150 - (QC5- Inspect part completeness to step on W/O)
- 160 - (QC9- Inspect visual per QSI004- Fusion Welds)
- 170 - (Chemical Conversion Coat per QSI005 4.1)
- 180 - (QC7-Inspect Chemical Conversion Coat)

Location WACO

190 - 1-Press bushing in D3560 arm per dwg D3562
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Identify as per dwg & Stock Location: _____), *** STOCK IN STEP CELL ***
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3560-2	Arm	4 pcs (1 ea)	140-Large Fab - Welded Assy-1	S14 7314 S061044 S 097179
D3592-1	Plate	4 Ea (1 ea)	140-Large Fab - Welded Assy-1	
D2808	Spacer	4 pcs (1 ea)	190-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
140-Large Fab - Welded Assy-1	D3560-2	4	0	0
	D3592-1	4	36	0
190-Small Fab - 2 - B4B	D2808	4	24	0

Part Specifications

Specifications could not be found.

7766

Plex 1/14/19 8:09 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

NCR No. 19-7336Job: 188643Part No. D3560-042

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Rework ☒	Scrap ☐	Use-as-is ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐
			Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐
			Large Fab ☒	Finishing ☐	Rec/Store/Packaging ☐
Sequence #: <u>150 QCS</u>		QTY Affected: <u>1</u>			
Date: <u>JAN 28 2019</u>		MRB (QSI042) <u>1/28/19</u>			
Description Work Order Deviation		Disposition			
<u>- AFTER WELDING PART D3560-2 TO PLATE D3560-1, A CRACK WAS DETECTED IN THE PLATE.</u>		<u>- REMOVE PLATE D3560-1 AND RE-WELD ANOTHER PART.</u>			
Completed By <u>[Signature]</u>		Completed By <u>[Signature]</u>			
DAS <u>68</u> 9-89		DAS <u>40</u> 9-89			
JUL 17 2019		JUL 17 2019			
QC / QA Coordinator		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☒	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☒	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details:				